

## ABSTRACT

A method of forming a three-dimensional object in a layerwise manner is disclosed. The object is formed in a manner that substantially prevents non-uniform distortion to occur during the layerwise build process as the build material forming the object solidifies and shrinks. The formed object comprises an outer surface defined by a shell structure and an internal lattice structure residing within the internal volume of the object. The object may be formed by any selective deposition modeling apparatus from a wide variety of materials.

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